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D4093-1

Job Sheet 203043



Part No: D4093-1

Job Qty: 8 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 12/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2 lpp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER REV C
11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	8 pcs		12/5/19	0.17	2.35	Waterjet - Flow <i>max</i>		<i>02/19/11/26</i>
120	QC 2	8 pcs		12/5/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>02/19/11/26</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130 Conventional Mill - 1 - B4B	8 pcs	12/5/19	0.00 4.85		Conventional Mill - 1 - B4B	N/A 11/11/19
					Conventional Mill - 2 - B4B	
135 QC 8	8 pcs	12/5/19	0.00 0.00		QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	D.A. 19-11-30
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	12/5/19	0.00 0.43		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	DEC 02 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	8 pcs	12/5/19	0.00 0.00		QC 7 - 10	

				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
170	Packaging 3-1 - Stock - B4B	8 pcs	12/5/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B

DEC 02 2019
DAS 40
9-89

DAS
28
9-89

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8	12/5/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 120 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 130 - (Manufacture as per dwg)
 135 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

DEC 04 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X06.000	6061T6 Bar .750 X 6.00	4.6400 ft (.58 ea)	110-Waterjet - Flow - 1	5127977

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6B0.750X06.000	5	22	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.920Inches $\pm$ 0.030	0.950 0.890		
2	Bracket	3.850Inches $\pm$ 0.030	3.880 3.820		
3	Bracket	4.030Inches $\pm$ 0.030	4.060 4.000		
4	Bracket	5.030Inches $\pm$ 0.030	5.060 5.000		
5	Bracket	0.360Inches $\pm$ 0.030	0.390 0.330		
6	Bracket	0.760Inches $\pm$ 0.030	0.790 0.730		
7	Bracket	4.820Inches $\pm$ 0.030	4.850 4.790		
8	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350		
9	Bracket	4.200Inches $\pm$ 0.030	4.230 4.170		
10	Bracket	7.030Inches $\pm$ 0.030	7.060 7.000		
11	Bracket	0.750Inches $\pm$ 0.010	0.760 0.740		
12	Bracket	0.080Inches $\pm$ 0.010 - 0.001	0.090 0.079	Diameter	
13	Bracket	0.201Inches $\pm$ 0.005 - 0.001	0.206 0.200	Diameter	
14	Bracket	0.500Inches $\pm$ 0.030	0.530 0.470		
15	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490		
16	Bracket	2.530Inches $\pm$ 0.010	2.540 2.520		
17	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490		
18	Bracket	0.201Inches $\pm$ 0.005 - 0.001	0.206 0.200	Diameter	
19	Bracket	0.370Inches $\pm$ 0.010	0.380 0.360	Diameter	
20	Bracket	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle	
21	Bracket	2.390Inches $\pm$ 0.030	2.420 2.360		
22	Bracket	1.580Inches $\pm$ 0.030	1.610 1.550		
23	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		
24	Bracket	1.130Inches $\pm$ 0.030	1.160 1.100		
25	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

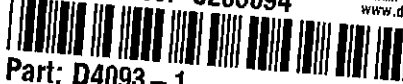
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



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Container No: S235094



Part: D4093-1

Job No: 203043

Serial No/Batch: S235094

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/26/19